

Work Order ID 58396

May 5, 2010 2:27:41 PM



Page 1

Item ID: D1049

Accept



Setup Start



Revision ID:

Item Name: Saddle

Stop



Start Date: 05/05/2010 Start Qty: 20.00



Cust Item ID:

Required Date: 12/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date: 10-5-05

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start



Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D1049

Rev A

100

0.00



SHEAR

Shear

Memo

0.00

Shear

Cut Blanks: 2.000" long

mt
10/06/16

20

0

110

0.00



HAAS CNC VERTICAL MACHINING #1

HAAS 1

Memo

0.00

HAAS CNC vertical machine #1

1-Machine as per folio FA217 & Dwg D1049
2-Deburr

mt
10/06/16

20

0

120

0.00



QC2- Inspect parts off machine FAI/FAIB

QC

Memo

0.00

Quality Control

mt
10/06/16

20

0

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

W/O:		WORK ORDER CHANGES					
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Page 3

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Start Date: 05/05/2010 Start Qty: 20.00



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Required Date: 12/05/2010 Req'd Qty: 20.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

m 10 02 22 20

170

Identify as per dwg & Stock Location: 2

0.00



Packaging

Memo

0.00

Packaging

10-6-22 20-23

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10/06/23 23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

May 5, 2010 2:28:03 PM

Page 1

Work Order ID: 58396



Parent Item: D1049



Parent Item Name: Saddle

Start Date: 05/05/2010

Required Date: 12/05/2010

Comments: IPP RevC 02.04.10 Re-format NG

Start Qty: 20.00

Required Qty: 20.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Qty Issued	Date Issued	Status
M6061T6B0.750X00.25 0		Purchased	No			100	f	20.0000	0.1666			



6061-T6 Bar .750 x .250

Location

Loc Qty

Loc Code

MAT02

~~20~~

+06747

~~20~~

M6061T6 .250 x 1.00 M103039

3.5

mc 10/06/10

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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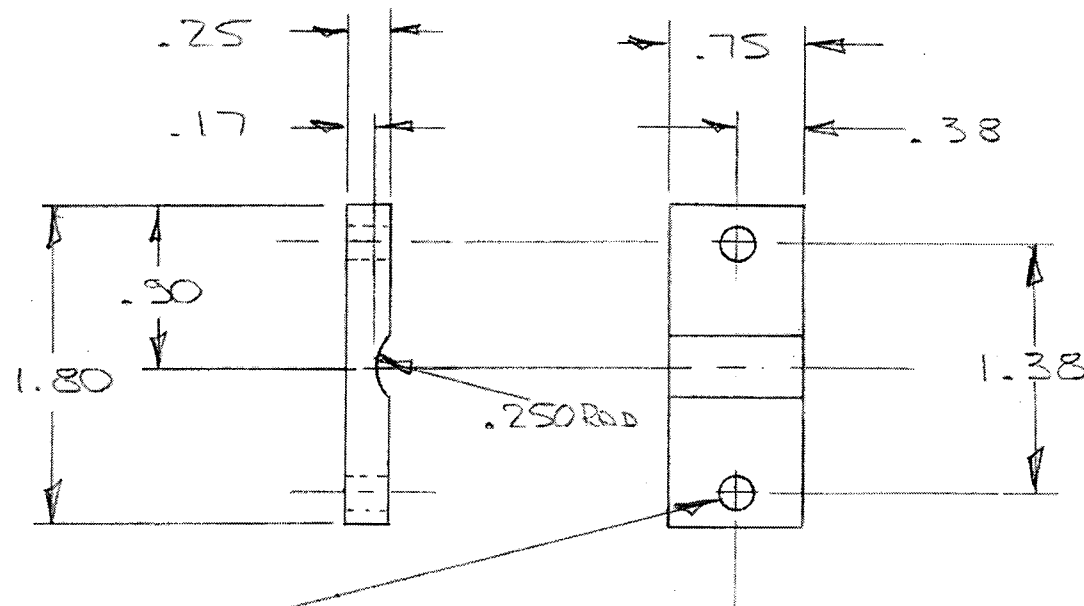
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

RELEASED
97/09/02 BW

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 58394

BP10-5-05



.203 DIA.
TYP

MATERIAL : 5052-H32

FINISH : POWDER COAT



REVISION	THIS DRAWING IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE PERMISSION OF DART AERO.		RIVET CODE SHALL BE PER NAS 523		PART NO.	ITEM	DESCRIPTION	MATERIAL	SPEC/VENDOR
DRAWN			BASIC CODE		CONTRACT NO.		DART DART AERO ACCESSORIES INC. VANCOUVER CANADA		
APPROVED			D=DRIPLE DIGIT NO OF SHEETS C=COUNTERSINK		DATE 17/11/02				
DESCRIPTION OF CHANGE	REQUIREMENTS — UNLESS OTHERWISE SPECIFIED		BASIC CODES		STRESS		TITLE		
	GENERAL	UNITS	BASIC CODES		CHECKED		CODE		
	1. DIMENSIONS ARE IN INCHES 2. SURFACE ROUGHNESS 125/1 3. REMOVE SHARP EDGES .015 MAX 4. THREADS PER NAS 5 - 7742 5. HOLES PER AND 10387		1. TOLERANCES — .001 & .002 2. ANGLES .001 & .010 3. PARALLELISM .0025 4. ECCENTRICITY .005 MAX 5. SYMMETRY ABOUT ALL H/C CENTRE LINES .005		LENGTH DASH NO. W=SPOTWELD		DNG NO D1049		REV
REPORT ALL DISCREPANCIES — DO NOT SCALE									

W/O:		WORK ORDER CHANGES					
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